

Date: Friday, 11/18/2005 3:18:54 PM
User: Linda Lacelle

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 24840	Part Number	: D2574
Estimate Number	: 10534	Drawing Number	: D2574 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 12/20/2005
Previous Run	: 244341	Qty:	12 Um: Each
Written By	: See Comment below		
Checked & Approved By	: See Comment below		
Comment	: Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: B21817A (4x) B21801 MS 06/01/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No B24840 Double check by: EN 06/01/09

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per MS 06/01/09
Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MS 06/01/09
4-Deburr and remove all machining marks MS 06/01/09
5-Tumble to remove sharp edges. N/A

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574 MS 06/01/09

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/01/09

2

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/01/09

2

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

06 01 09

2

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS

06 01 10

2

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS 06/01/10

2

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ✓

MS 06/01/10

2

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

MS

06/01/11

2

Job Completion



JART AEROSPACE LTD	Work Order:	
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	✓	✓			
B	1.745	1.755		1.754	1.752	1.750			
C	3.495	3.505		3.501	3.500	2.			
D	1.745	1.755		1.753	1.751	1.750			
E	7.990	8.010		8.005	8.002	8.001			
F	0.490	0.510		0.501	.500	.497			
G	0.257	0.262	DT8683	0.258	0.258	✓			
H	0.375	0.380	DT8684	0.376	0.376	✓			
I	0.490	0.510		0.498	.502	.499			
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		0.674	.511	.568			
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.371	1.370	1.370		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.122			
P	0.115	0.135		0.125	.128	.130			
Q	0.115	0.135		0.150	.133	.133	.128		
R	0.240	0.260		0.252	.250	.252			
S	0.115	0.135		0.123	.126	.127			
T	0.178	0.198		0.1875	.188	.188			
U	3.210	3.250		3.230	3.231	3.233			
V	0.230	0.250		0.243	.244	.240			
W	0.115	0.135		0.082	.132	.135			
X	0.307	0.312			.312	.312			
Y	0.760	0.765			.762	.762			
Z	0.352	0.372		0.357	.371	.362			
AA	0.470	0.530		0.500	.500	.500			
AB	0.615	0.635		0.632	.628	.628			
AC	0.053	0.073		0.063	.063	.063			
AD	0.240	0.260		0.160	.250	.250			
AE	1.500	1.520		1.514	1.511	1.512			
AF	0.115	0.135		0.125	.133	.133			
AG	0.240	0.280		0.255	.260	.252			
AH	0.240	0.260		0.248	.250	.250			
AI	2.000	2.020		2.002	2.002	2.002			
AJ	0.023	0.043			.029	.030			
Accept/Reject				Reject					

Measured by:	MS 06/01/09
Date:	06/01/09

Audited by:	ML
Date:	06/01/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
05.12.09